WORK INSTRUCTION

Title: **ICV/OCV Lid & Body Seal Flange Tab Width Measurements**

Instruction No. CH.09 Rev. 0, January 2002

Approved for Use by: Michael R. Brown Effective Date: January 2002

Applicable Drawings:
- 2077-500SNP (Sheets 1, 7, and 8) - TRUPACT-II Packaging SARP Drawings
- 707-SAR (Sheets 1, 6 & 10) - HalfPACT Packaging SARP Drawings

SARP Requirements:
- Chapter 8.0. Prior to first use and annually thereafter.

Tools Required:
- ICV/OCV lid and body seal flange tab width GO NO-GO Gauge as shown in SARP
- Calipers

Spare Parts Required:
- None

Materials Required:
- None

Safety Requirements:
- Safety will be observed in accordance with site requirements.

Prerequisite Conditions:
- OCV and ICV lids are removed.

Instruction Steps:
- Record all data from this instruction on the attached data sheet (Attachment 2) to this instruction.
- This instruction **is not required to be attached** to the Maintenance Record but may be used as a checklist during performance of maintenance.

NOTE: Gently set “go/no-go” gauge down onto body seal flange. Do not slide gauge around flange or exert downward pressure. See Attachment 1, Figures A & B for examples of Lid Tab and Body Tab Measurement Technique. See Attachment 1, Figure C, for caliper measurement technique of the ICV lid tab.

NOTE: The Go-No/Go gauge used to check the body and lid tab width shall have the dimensions referenced in SARP Chapter 8.

1.0 At 18 locations on the lid and body, perform the Lid and Body Tab Width Measurements.

NOTE: The location does not have to be exact: measurements should be taken at the approximate center of the locking lugs.

2.0 Check completion of each measurement using Attachment 2, (Data Sheet).

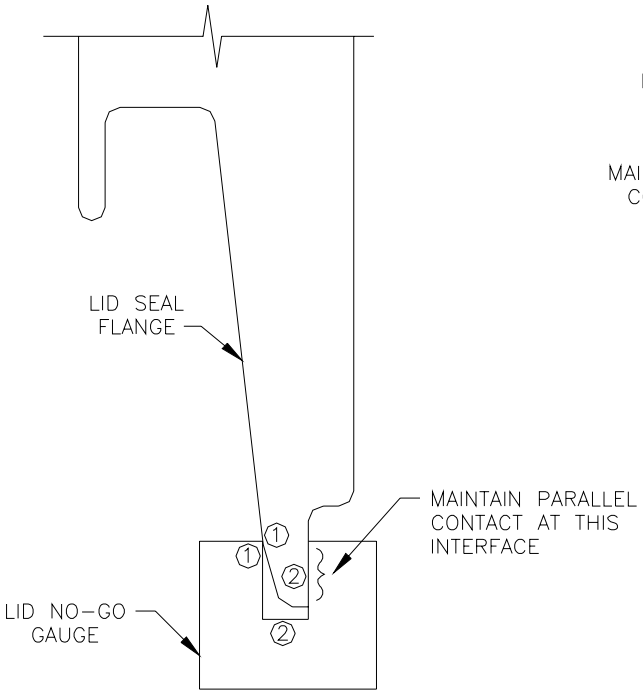
NOTE: If any location is found to be marginal using the no-go gauge then use the measuring method in Attachment 1, Figure C.

3.0 If any location is found to be out of tolerance notify the CH Packaging Maintenance Engineer.

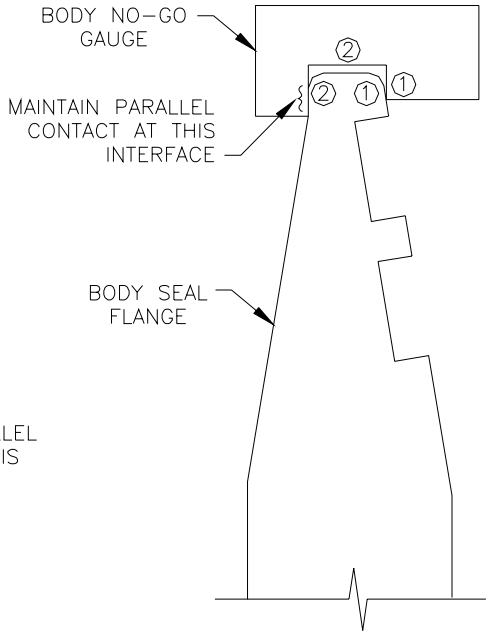
Verification Requirements:

1.0 Work performed is described on Maintenance Record.
2.0 Work Instruction is listed on Maintenance Record.
3.0 Data sheet (Work Instruction CH.09, Attachment 2) is attached to Maintenance Record.

ATTACHMENT 1



ICV/OCV UPPER SEAL FLANGE (LID)
TAB WIDTH MEASUREMENT
(FIGURE A)

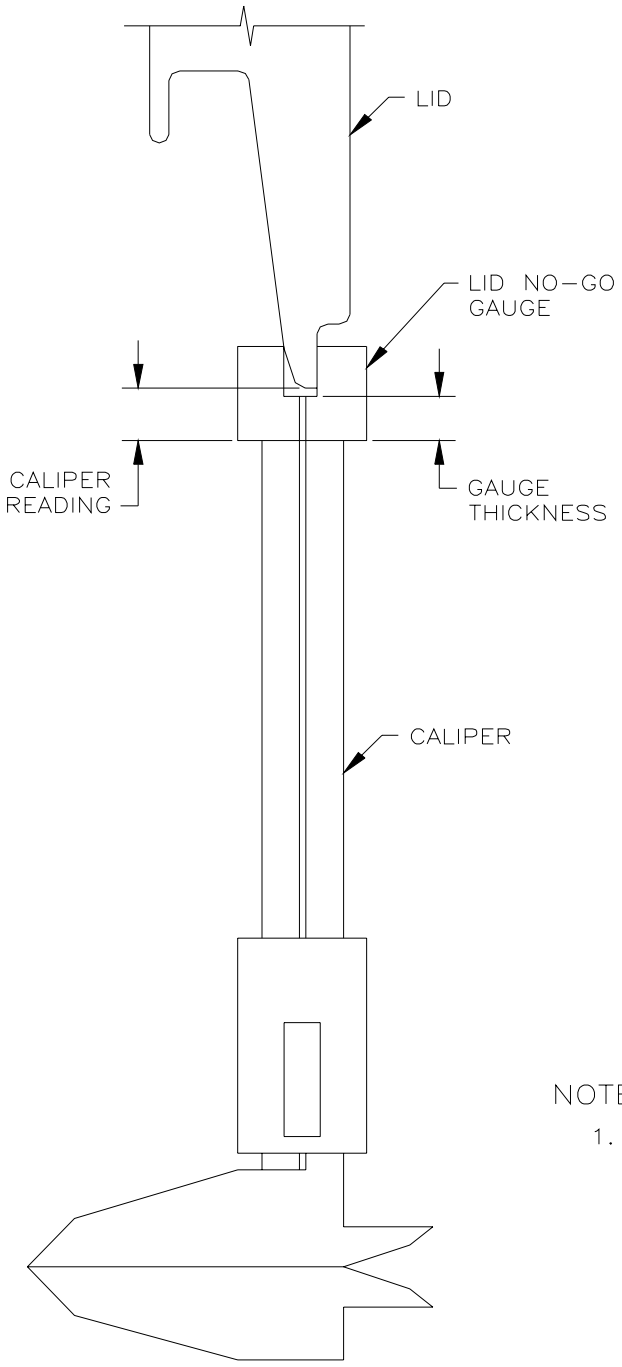


ICV/OCV LOWER SEAL FLANGE (BODY)
TAB WIDTH MEASUREMENT
(FIGURE B)

NOTES

1. CONTACT AT LOCATION 1-1 AND GAP AT LOCATION 2-2 IS A "NO-GO" CONDITION INDICATING THAT THE TAB WIDTH IS ACCEPTABLE.
2. CONTACT OR A GAP AT LOCATION 1-1 AND CONTACT AT LOCATION 2-2 IS A GO CONDITION INDICATIING THE TAB WIDTH IS UNACCEPTABLE.

ATTACHMENT 1



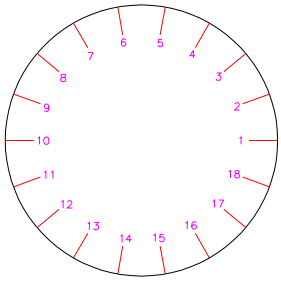
NOTE

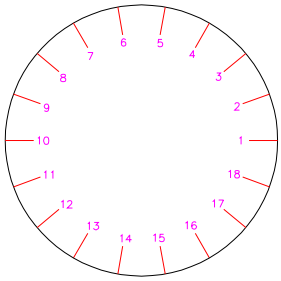
1. IF A CALIPER READING IS GREATER THAN GAUGE THICKNESS THEN THE TAB WIDTH IS ACCEPTABLE.

(FIGURE C)

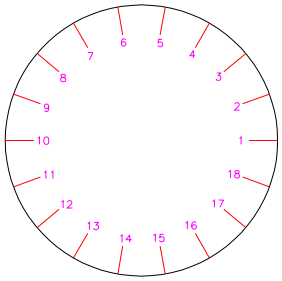
ATTACHMENT 2 - ICV/OCV LID AND BODY TAB WIDTHS

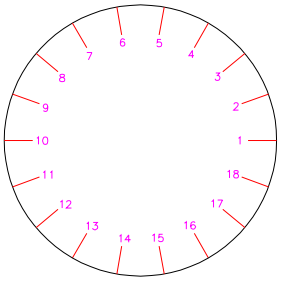
Packaging S/N: _____ Date: _____ Job No. _____





Reference from Seal Test Port





Reference from Seal Test Port

ICV LID		ICV BODY		OCV LID		OCV BODY	
Loc.	√*	Loc.	√*	Loc.	√*	Loc.	√*
1.		1.		1.		1.	
2.		2.		2.		2.	
3.		3.		3.		3.	
4.		4.		4.		4.	
5.		5.		5.		5.	
6.		6.		6.		6.	
7.		7.		7.		7.	
8.		8.		8.		8.	
9.		9.		9.		9.	
10.		10.		10.		10.	
11.		11.		11.		11.	
12.		12.		12.		12.	
13.		13.		13.		13.	
14.		14.		14.		14.	
15.		15.		15.		15.	
16.		16.		16.		16.	
17.		17.		17.		17.	
18.		18.		18.		18.	

INSPECTION:	SAT	UNSAT	INSPECTION:	SAT	UNSAT
ICV lid			OCV lid		
ICV body			OCV body		

*All deficiencies noted on Maintenance Record

ICV/OCV Body Tab Width Gauge S/N: _____ Calibration Due Date: _____

ICV/OCV Lid Tab Width Gauge S/N: _____ Calibration Due Date: _____

Caliper S/N: _____ Calibration Due Date: _____ (N/A if not used)

QA: _____ Date: _____